

Work Order ID 165759

Monday, August 28, 2017 10:53:59 AM

165759

Page 1

Item ID: D3801-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Hand Retractable Spring Plunger
Start Date: 8/28/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 9/6/2017 Req'd Qty: 10.00 ***10*** Customer:

Reference: **DAS**
13
9-89
Approvals: Process Plan: **DAS** Date: **AUG 28 2017** Tooling: Date: **Run Start *NR1***
QC: Date: SPC (Y/N): Date: **Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3801	B								
100	PURCHASING	0.00							DAS 13 9-89
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 37575								
	Purchase Part Number: KBP-504								
	Supplier: Essentra								
	Certificate of conformity is required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.20							
Packaging	Ensure material certification is attached								
120	QC6- All purchased or subcontracted products	0.00							
120									
QC	Memo	0.00							
Quality Control	Ensure Material certification comply to Dwg D3801								DAS 9 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 165759***165759***

Page 2

Item ID: D3801-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hand Retractable Spring Plunger

Start Date: 8/28/2017 Start Qty: 10.00

10

Cust Item ID:

Required Date: 9/6/2017 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>Sto 2</u>	0.00							
130									
Packaging	Memo	0.10							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	1.00							
Quality Control									

10
DAS
6
9-89
SEP 19 2017

17/9/20

SEP 19 2017

DAS
21
9-89

SEP 19 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Monday, August 28, 2017 10:53:58 AM

[illegible]

DQA: _____ Date: _____

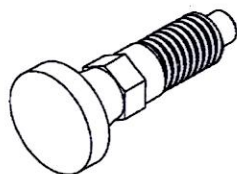


WORK ORDER NON-CONFORMANCE / UPDATE

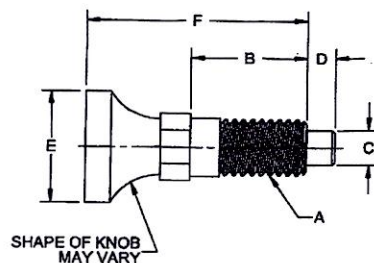
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



SPECIFICATION CONTROL DRAWING



AUG 7 8 2017
DAS
13
9-89

W/O: 165759

D3801-X HAND RETRACTABLE SPRING PLUNGER

DART P/N	SUPPLIER	SUPPLIER P/N	'A' THREAD SIZE	'B' THREAD LENGTH	'C' NOSE DIAMETER	'D' NOSE LENGTH	'E' HEAD DIAMETER	'F' LENGTH	'G' WIDTH ACROSS FLATS	MATERIAL (BODY/ NOSE)	MATERIAL (KNOB)	TYPE	END FORCE (lbs)	WEIGHT (lbs)
D3801-1	REID SUPPLY COMPANY	KBP-504	3/8-24 UNF	0.67	0.197	0.20	0.83	1.71	0.50	303 SS	BLACK DELRIN	NON-LOCKING	2.7	0.01
D3801-3	REID SUPPLY COMPANY	PRT-22 OR PRT-22N	1/2-13 UNC	1.00	0.313	0.25	1.00	1.90	0.52	303 SS	WHITE DELRIN	NON-LOCKING	1.75	0.02

△B

△B

- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A

RELEASED
2012-03-02

B	SUPPLIER P/N CHANGED: BODY/NOSE MAT'L WAS STEEL NOW STAINLESS STEEL.	MB	12.02.24
A	NEW ISSUE	MB	08.06.19
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.02.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3801** REV. B
SHEET 1 OF 1

TITLE: **HAND RETRACTABLE SPRING PLUNGER** NTS

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37575**

Purchase Order Date 8/28/2017

PO Print Date 8/28/2017

Page Number 1 of 2

Order From :
ESSENTRA COMPONENTS
P.O. BOX 9900 T-9915
POSTAL STATION A
TORONTO, ONTARIO M5M 2J2
CANADA

VC-ESS001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

AUG 28 2017

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

Ship Via: FedEx Economy collect

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	KBP-504	Hand Retractable Spring Plunger	9/5/2017		10.00	\$24.46	\$244.60
			Yes		Each		
			9/5/2017				
	AS PER DWG D3801 REV. B B165759						
	DAS 9 9-89						
						Line Total:	\$244.60
2	KCL-208	Cam Lever	9/5/2017		10.00	\$29.32	\$293.20
			Yes		Each		
			9/5/2017				
	AS PER DWG D2372 REV. B B165760						
						Line Total:	\$293.20
3	BLRS-010	Quick Release Pin (1/4" x 1")	9/5/2017	FN	5.00	\$32.86	\$164.28
			Yes		Each		
			9/5/2017				

Note:

8/28/2017



Essentra Components
2538 Speers Road, Unit 7
Oakville, ON L6L 5K9
Phone: 905-825-0134
Fax: 905-825-2919
www.essentracomponents.com

Packing List
LOAD NUMBER 782009
SID/INV 1743505
CUSTOMER PO PO37575
ORDER NUMBER 2458627
CARRIER Fed Ex Ground
SHIP DATE 08/31/17
FOB DESCRIPTION COL

SOLD TO 422854
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

DELIVERY TO 422854
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

LINE NO	PART NO. DESCRIPTION	ORIGINAL QUANTITY	QUANTITY SHIPPED	CTNS	NET WEIGHT	TOTAL WEIGHT
1	KBP-504 3/8-24 NON-LOCKING SS PULL INDEXING PLUNGER Cust Order #: PO37575 Country Of Origin: DE	10.000	10.000	10	.47	1.47
2	KCL-208 CAM LEVER 2.77 SS ADJ CAM LEVER 1/4-20 X 1.18 STUD Cust Order #: PO37575 Country Of Origin: DE	10.000	10.000	10	1.60	2.60
3	BLRS-010A 1/4 X 1 SS BL PIN R-HANDLE Cust Order #: PO37575 Country Of Origin: US	5.000	5.000	5	.25	1.25
4	BLRS-020A B154874	5.000	5.000	5	.19	1.19

Certificate of Compliance

This is to certify that the above material shipped against your purchase order is in conformance with all known requirements, specifications and drawings in effect at the time of manufacture. All applicable physical, functional, dimensional and material test reports are on file at our facility, and may be inspected by your representative upon request.

Richard Queer
Quality Assurance Manager